


Work Order ID 125621

125621

Page 1

Thursday, October 16, 2014 2:26:49 PM

Item ID: D4941-4L02 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector, Aft RH, (Black)
 Start Date: 10/17/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/24/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan:  Date: 14-10-16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4941	D

100	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89
100						x2			
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								14/10/16

105	Dry Material	0.00							DAS 07 9-89
105						x2			
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								14/10/16

Temp: **245 deg. F**
 Time IN: **5:00 PM**
 Time OUT: **6:00 AM**

OCT 15 2014

Per. 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Thursday, October 16, 2014 2:26:49 PM

Item ID: D4941-4L02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector, Aft RH, (Black)

Start Date: 10/17/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 10/24/14 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	THERMOFORMING MACHINE	0.00							DAS 07 9-89

110

THERMOFORMING MACHINE

Thermoform

Memo

Thermoforming Machine

Thermoform as per Dwg. D4941 and Folio FTA 161

Dwg. Rev. 0
Folio Rev. 2

130

HAND FINISHING THERMOFORMING

130

Memo

Thermoforming Machine

Trim to Finished Dimensions

140

QC2- Inspect parts off machine FAI/FAIB

140

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

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Picklist Print

Thursday, October 16, 2014 2:26:52 PM

Page 1

Work Order ID: 125621

125621

Parent Item: D4941-4L02

D4941-4L 02

Parent Item Name: Floor Protector, Aft RH, (Black)

Start Date: 10/17/14

Required Date: 10/24/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02

IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev. D Revised Dwg. 14/07/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F6006-02

Purchased

No

100

sf

1,979.880

4.875

10

DAS
07
9-89

MI FXS 125-F6006-02

GE PLASTICS LEXAN SHEET(BLACK)

Location

Loc Qty

Loc Code

MAT018

4.3

m128887

4.3

waterjet

1975.58

m128887

1975.58

17/10/30.

18 sg 84.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

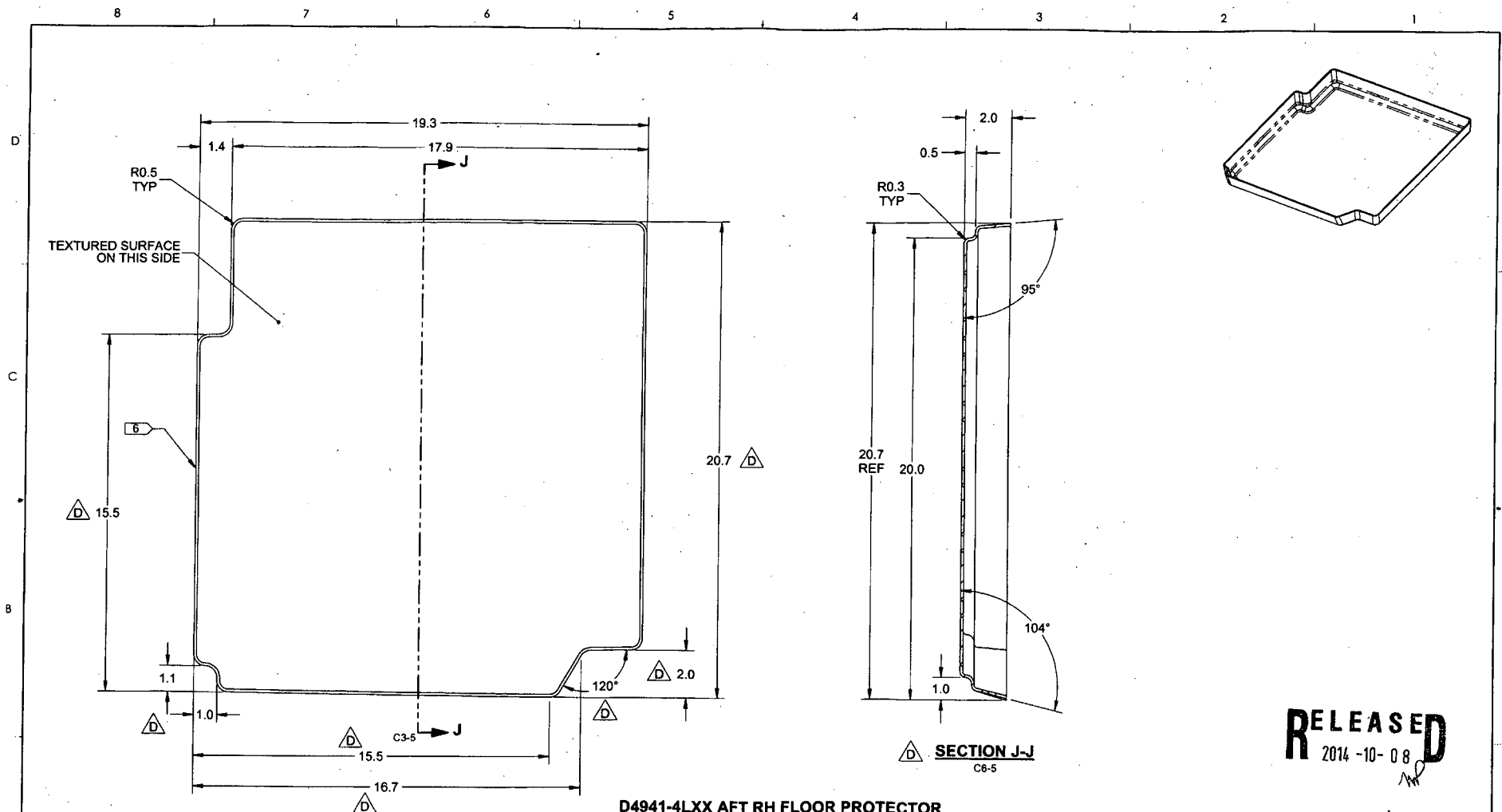
Work Order update only ☐

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FAULT CATEGORY

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RELEASED
2014-10-08

D4941-4LXX AFT RH FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
- 7) WEIGHT: 1.9 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9993 TRIM PER MOLD LEAVING FINISHED EDGES
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

14-10-16
125621

PART NUMBER	DESCRIPTION
D4941-4L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-4L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

APPROVED

DESIGN	AK	<div style="font-size: 1.2em; font-weight: bold; margin-bottom: 5px;">DART AEROSPACE LTD</div> <div style="margin-bottom: 5px;">HAWKESBURY, ONTARIO, CANADA</div> <div style="display: flex; justify-content: space-between;"> <div> DRAWING NO. <div style="font-size: 1.2em; font-weight: bold;">D4941</div> </div> <div> REV. D <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> </div> <div style="display: flex; justify-content: space-between;"> <div> MFG. APPR. <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> <div> SHEET 5 OF 5 <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> </div> <div style="display: flex; justify-content: space-between;"> <div> APPROVED <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> <div> SCALE <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> </div> <div style="display: flex; justify-content: space-between;"> <div> DE APPR. <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> <div> NTS <div style="border-bottom: 1px solid black; width: 100px;"></div> </div> </div>
DRAWN	AK	
CHECKED	VS	
MFG. APPR.	DL	
APPROVED	HS	
DE APPR.	DS	
DATE 14.07.25		<div style="font-size: 0.8em; margin-top: 10px;"> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </div>